

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016153**Date Inspected:** 11-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face A
- 2). OBG Field Splice 4W/5W Weld ID: C1& C2, Face A
- 3). OBG Field Splice 5W/6W Weld ID: B1, Face B

- 1). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face A

The QAI periodically observed AB/F approved welders Fred Kaddu (ID 2188) and Kenneth Chappell (3833) performing excavating by grinding at Ultrasonic Testing (UT) repair cycle one (R-1) reject areas. Later in the shift the QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing repair welding per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position. The QAI periodically observed the QC Inspector Tom Pasqualone was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1. 5-1000-Repair and the QAI observed the QC Inspector performing Magnetic Particle Testing (MT) of the repair excavation prior to welding. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. Work at this location was in process and appeared to be in general compliance with contract documents.

- 2). OBG Field Splice 4W/5W Weld ID: C1& C2, Face A

The QAI periodically observed AB/F approved welder Song Tao Huang (ID 3794) performing welding per the

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Flux Cored Arc Welding (FCAW-G) process in the 3G (vertical) position of fill and cover passes on weld ID: C2. Later in the shift the QAI periodically observed AB/F approved welder Song Tao Huang (ID 3794) and Salvador Sandoval (ID 2202) setting up to perform FCAW-G of weld ID: C1 in the 3G (vertical) position. The QAI observed QC Inspector Tony Sherwood was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3042B-1. When welding of weld C1 commenced, the QC Inspector stated that the welding amperes were measured at 252 amps, the welding volts were 24.2 volts and the travel speed was measured to be 227 mm/min. The work at this location was in process for the duration of the QA Inspectors shift and appeared to be in general compliance with contract documents. See Summary of Conversations.

3). OBG Field Splice 5W/6W Weld ID: B1, Face B

The QAI periodically observed the in process fillet welding of the A1 Interior Radius Transition at Deck Corner area at the weld A1 backing bar termination location. The welding was being performed by approved AB/F welder Hua Qiang Hwang (2930) The QAI observed QC Inspector Tony Sherwood was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-F1200A. The QAI observed that a small backing bar section was tacked in place on the B face of weld B1 adjacent to weld C1. See Summary of Conversations. Work at this location was in process for the duration of the QA Inspectors shift and appeared to be in general compliance with contract documents.



Summary of Conversations:

From item 2).

The QC technician Tony Sherwood in a conversation with the QAI stated that the QC UT was completed and the twelve (12) R-1 repair locations were all UT accepted for welds D1 & D2 at OBG Field Splice 3W/4W. The QAI later approached QC Mike Johnson and asked if the welds D1 & D2 at OBG Field Splice 3W/4W were ready for the QA Verification UT Inspection. Mr. Johnson stated that he didn't know but that he doubted it was ready for QA. QC Inspector Jesse Cayabyab arrived and stated that the QC UT was completed and accepted and that he believed that QA Inspector Mr. Danny Reyes had already performed the verification on 8-10-2001.

From item 3).

The QC technician Tony Sherwood in a conversation with the QAI stated that when welder Hua Qiang Hwang finished fillet welding at the radius/transition area that the welder was going to go to the A face and perform CJP welding of the hole at the bottom of weld B1 where it meets weld C1. The QC inspector stated that there was a

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piece of backing bar already tacked on the B face of B1.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

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| Inspected By: | Madison,Bert |
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| Quality Assurance Inspector |
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| Reviewed By: | Levell,Bill |
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| QA Reviewer |
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